

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018234**Date Inspected:** 17-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bike Path-DCP**

-During random DCP check, this QA inspector observed out of flatness across the weld exceed the allowable tolerance.

-The component is Bike Path bottom cover plate, seam weld.

-The thickness of the bottom plate is 6mm.

-According to the Standard Specification 1999, Section 55, flatness of the splice weld is measured by 600mm straight edge and the allowable tolerance is 5mm.

-Maximum out of flatness was observed as 9.5mm on bike path BK004A-021, weld#BK004A2-021-016,

And 7.5mm on bike path BK004A-018, weld#BK004A2-018-018.

For further information, please find attached pictures

**Bay#19**

During random visual observation of the bike path, this QA inspector observed following issues.

-The slotted hole on the Bike Path Bearing Plate does not comply with the approved shop drawing.

-According to the shop drawing, the dimension of the slotted hole is 64x34.

-The slotted holes were measured as 45x34.

-The bearing Plate is identified as BKPL7A (BK004A) and BKPL14A (BK006A)

-The bike path component is identified as; BK006A-001, BK004A-012 and BK004A-005.

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-The bike paths are located inside bay#19.  
For further information, please find attached pictures

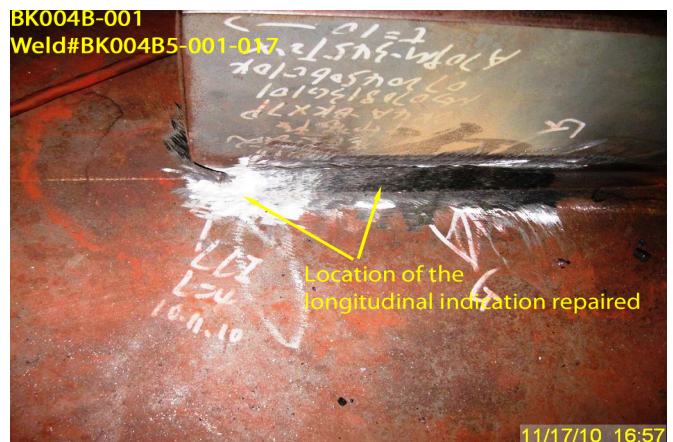
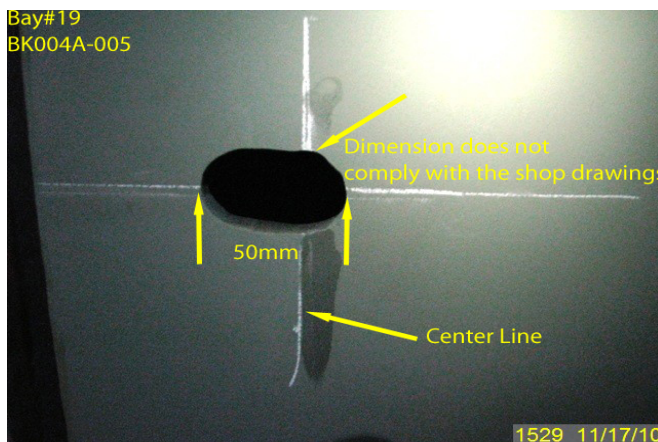
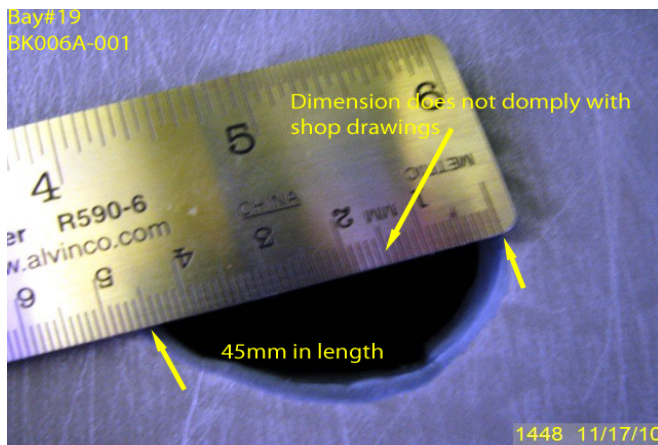
## Bay#19 CWR Verification.

During Quality Assurance (QA) Critical Weld Repair (CWR) verification inspection at Bay#19 of Bike Path welds, this Caltrans QA Inspector observed the following issues:

- QA Inspector was notified via email for verification of B-CWR2228 R0 at 16:25 hours.
- The Bike Path component for verification was identified as BK004B-001.
- The welds are identified as; BK004B3-001-051, total three (3) linear transverse indications  
And BK004B5-001-017, total four (4) linear longitudinal indications.
- The transverse indications measuring approximately 10mm & 15mm in length and the longitudinal indications measuring approximately 15mm & 25mm were found at this location, which required an approved CWR prior to starting repairs.
- ZPMC repaired these indications prior to the QA inspector's CWR verification.
- BK004B-001 is located in Bay 19.

For further information, please see the attached pictures below. Please see incident report on this date.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

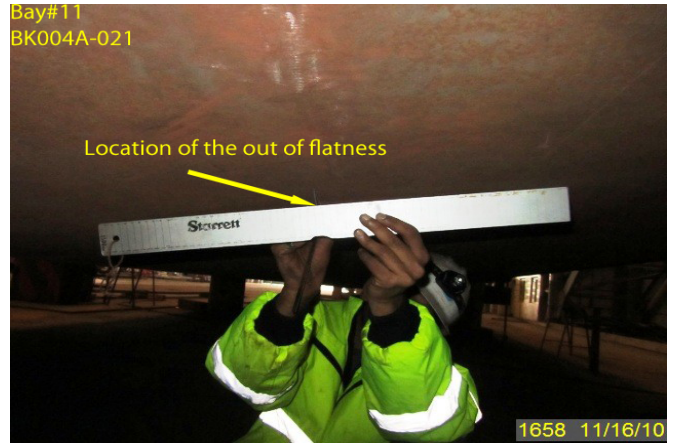


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## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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